

I claim:

1. A bottle closure formed by injection molding, comprising:
  - (a) a body member having a generally cylindrical portion and at least one generally circular end portion; and
  - 5 (b) markings molded into the end portion during the injection molding process.
2. A bottle closure as defined in claim 1, wherein the markings are selected from the group consisting of designs, logotypes, names, information identifying the contents of the  
10 bottle, and information identifying the producer of the contents of the bottle.
3. A bottle closure as defined in claim 1, wherein the body member has two generally circular end portions, the markings are molded into each end portion during the injection molding process, and the markings are substantially identical.  
15
4. A bottle closure as defined in claim 1, further comprising an enlarged portion of the body member.
5. A bottle closure as defined in claim 4, wherein the body member is substantially  
20 T-shaped in longitudinal cross section.
6. A method of injection molding a bottle closure, comprising the steps of:
  - (a) providing an injection molding machine having a mold cavity for molding a bottle closure comprising a body member having a generally cylindrical  
25 portion and at least one generally circular end portion;
  - (b) creating a plate with reverse markings;
  - (c) releasably securing the plate in the mold cavity adjacent the portion of the mold cavity forming the end portion;
  - (d) injecting an injection mixture into the mold cavity; and
  - 30 (e) discharging a bottle closure having positive markings on one or both of its end portions.

7. A method as defined in claim 6, wherein the markings are selected from the group consisting of designs, logotypes, names, information identifying the contents of the bottle, and information identifying the producer of the contents of the bottle.

5

8. A method as defined in claim 6 wherein the body member has two generally circular end portions, further comprising the steps of:

- (a) forming the reverse markings into a second plate; and
- (b) releasably securing the second plate in the mold cavity adjacent the portion of the mold cavity forming the second end portion to create substantially identical markings in the second end portion.

10

9. A method as defined in claim 6, further comprising an enlarged portion or the body member.

15

10. A method as defined in claim 9, wherein the body member is substantially T-shaped in longitudinal cross section.